



Bergamid™ PA6-GL30 BK356

Polyamide 6

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Ash Content	30 %	30 %	ISO 3451
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress			ISO 527-2/5
Break, 73°F (23°C), 0.157 in (4.00 mm)	22500 psi	155 MPa	
Flexural Stress	34100 psi	235 MPa	ISO 178
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Charpy Notched Impact Strength ² (73°F (23°C))	4.8 ft·lb/in ²	10 kJ/m ²	DIN 53453
Charpy Unnotched Impact Strength ² 73°F (23°C)	21 ft·lb/in ²	45 kJ/m ²	DIN 53453
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Ball Indentation Hardness	27600 psi	190 MPa	ISO 2039-1
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	401 °F	205 °C	ASTM D648

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 212 °F	80 to 100 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	464 to 518 °F	240 to 270 °C
Middle Temperature	464 to 518 °F	240 to 270 °C
Front Temperature	482 to 536 °F	250 to 280 °C
Mold Temperature	149 to 185 °F	65 to 85 °C
Injection Notes		
Injection Pressure: MED-HIGH		
Hold Pressure: MED-HIGH		
Screw Speed: MODERATE		
Back Pressure: LOW		

Notes

¹ Typical values are not to be construed as specifications.

² specimen size: 50*6*4(mm)

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